

What is claimed is:

1. A method of forming a gate electrode, comprising:
  - forming a first layer of a first material having a first work function on a substrate;
  - forming a second layer of a second material over the first layer, the second material having a second work function; and
  - removing a portion of the first and second layers;wherein a stack formed by the first and second layers has a work function that is between the first work function and the second work function.
2. The method Claim 1, wherein the substrate is a silicon wafer with an insulating layer formed thereon.
3. The method of Claim 2, wherein the insulating layer comprises an oxide of silicon.
4. The method of Claim 2, wherein the second layer is substantially thicker than the first layer.
5. The method of Claim 2, further comprising providing an optimal channel doping for a predetermined relationship between an on current,  $I_{on}$ , and an off current,  $I_{off}$ .

1 6. An insulated gate FET, comprising:  
2 a gate dielectric layer disposed on a substrate;  
3 a gate electrode disposed over the gate dielectric; and  
4 a pair of source/drain regions disposed in the substrate along laterally  
5 opposed sidewalls of the gate electrode;  
6 wherein the gate electrode comprises a first material superjacent the gate  
7 dielectric, a second material superjacent the first the first material, the first  
8 material being a diffusion barrier with respect to the second material, and the  
9 thickness of the first material is such that the work function of the gate electrode  
10 is the work function of the second material.

1 7. The insulated gate FET of Claim 6, wherein the first material comprises  
2 TiN, and the second material comprises Al.

1 8. The insulated gate FET of Claim 6, wherein the first material comprises  
2 TiN, and the second material comprises Pd.

1 9. The insulated gate FET of Claim 6, wherein the first material comprises  
2 TaN, and the second material comprises Pd.

1 10. A method of tuning the work function of a gate electrode, comprising:  
2 forming a layer of a first conductive material superjacent a gate dielectric;  
3 and

5 forming a layer of a second conductive material superjacent the first  
6 conductive material;

7 wherein the thickness of the first conductive material is greater than a first  
critical thickness and less than a second critical thickness.

1 11. The method of Claim 10, wherein the first conductive material comprises a  
2 material selected from the group consisting of TiN, and TaN.

1 12. The method of Claim 10, wherein the second conductive material  
2 comprises a material selected from the group consisting of Al, Ti, Ta, Ni, Pd, and  
3 Pt.

1 13. The method of Claim 10, wherein the first conductive material comprises  
2 TiN, the second material comprises Al, the first critical thickness is approximately  
3 20 angstroms and the second critical thickness is approximately 100 angstroms.

1 14. A method of making a field effect transistor, comprising:  
2 forming a gate dielectric disposed on a semiconductor, a gate electrode  
3 comprising a first material disposed over the gate dielectric, and a pair of  
4 source/drain regions substantially disposed in the semiconductor and aligned to  
5 laterally opposed sidewalls of the gate electrode; and  
6 forming a work function modulation layer comprising a second material  
7 disposed intermediate the gate dielectric and the gate electrode, wherein the

8 thickness of the work function modulation layer is such that the work function of  
9 the gate electrode is different than the work function of the first material and  
10 different from the work function of the second material.

1 15. The method of Claim 14, wherein the work function modulation layer acts  
2 as a diffusion barrier to substantially preclude diffusion of the first material into  
3 the gate dielectric.

1 16. The method of Claim 14, wherein the work function modulation layer is  
2 titanium nitride.

1 17. The method of Claim 15, wherein the work function modulation layer is  
2 tantalum nitride.

1 18. An integrated circuit, comprising:  
2 an n-channel FET having a gate electrode comprising a first TiN layer  
3 superjacent a first gate dielectric and an Al layer superjacent the first TiN layer;  
4 and  
5 a p-channel FET having a gate electrode comprising a second TiN layer  
6 superjacent a second gate dielectric and a Pd layer superjacent the second TiN  
7 layer.

1 19. The integrated circuit of Claim 18, wherein the first TiN layer is between  
2 approximately one atomic monolayer and 100 angstroms thick; and the second  
3 TiN layer is between one atomic monolayer and 100 angstroms thick.

1 20. The integrated circuit of Claim 18, wherein the first TiN is approximately  
2 10 angstroms thick and the second TiN is approximately 20 angstroms thick.

1 21. An integrated circuit, comprising:  
2 an n-channel FET having a gate electrode comprising a TiN layer  
3 superjacent a first gate dielectric and an Al layer superjacent the TiN layer; and  
4 a p-channel FET having a gate electrode comprising a TaN layer  
5 superjacent a second gate dielectric and a Pd layer superjacent the TaN layer.

1 22. The integrated circuit of Claim 21, wherein the TiN layer is between  
2 approximately one atomic monolayer and 100 angstroms thick; and the TaN  
3 layer is between one atomic monolayer and 100 angstroms thick.

1 23. The integrated circuit of Claim 21, wherein the TiN is approximately 20  
2 angstroms thick.

1 24. The integrated circuit of Claim 23, wherein the TiN is an Al diffusion  
2 barrier, and the TaN is a Pd diffusion barrier.

- 1 25. An integrated circuit, comprising:  
2 a first FET of a first conductivity type, the first FET having a first work  
3 function modulation layer; and  
4 a second FET of the first conductivity type; the second FET having a  
5 second work function modulation layer;  
6 wherein the first and second work function modulation layers comprise the  
7 same material, and the thickness of the first work function modulation layer is  
8 different than the thickness of the second work function modulation layer.

- 1 26. The integrated circuit of Claim 25, wherein the first and second FETs have  
2 substantially identical channel doping profiles and the first and second FETs  
3 have different threshold voltages.
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